

# Work Order ID 73304

Wednesday, August 31, 2011 10:46:49 AM



Page 1

Item ID: D2621

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Plate, 350 Spacepod

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

*MF*

Date: *11-09-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2621

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2621

Dwg Rev: *B*

Prog Rev: *B*

2-

Deburr if necessary

*5052.046*

*B11-9-21*



110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-9-21*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*5105/21*

*wms*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73304

Wednesday, August 31, 2011 10:46:50 AM



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Item ID: D2621

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Plate, 350 Spacepod

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

52 counted  $\phi$  11/09/21

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

COVEN TEMPERATURE:

FINISH TIME:

M115128

3200F

9:45

10:15

52x  $\phi$  M 11/09/23

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

52  $\phi$  11/09/21  
counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 73304**

Wednesday, August 31, 2011 10:46:50 AM



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Item ID: D2621

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Plate, 350 Spacepod

Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start



QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location: 19-

0.00



Packaging

Memo

0.00

Packaging

11/9/23 JF S2

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/27 JF  
MF  
11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 10:46:46 AM

Page 1

Work Order ID: 73304

Parent Item: D2621

Parent Item Name: Latch Plate, 350 Spacepod





Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C02.02.28 Added inspection level 8 and level 5 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			110	sf	84.3000	0.0625	1.315789	3.5		
 													
5052-H32 .040 Sheet													

B11-9-21

Location

Loc Qty

Loc Code

MAT022

84.3

117130

20.3

118641

64

117130

(52)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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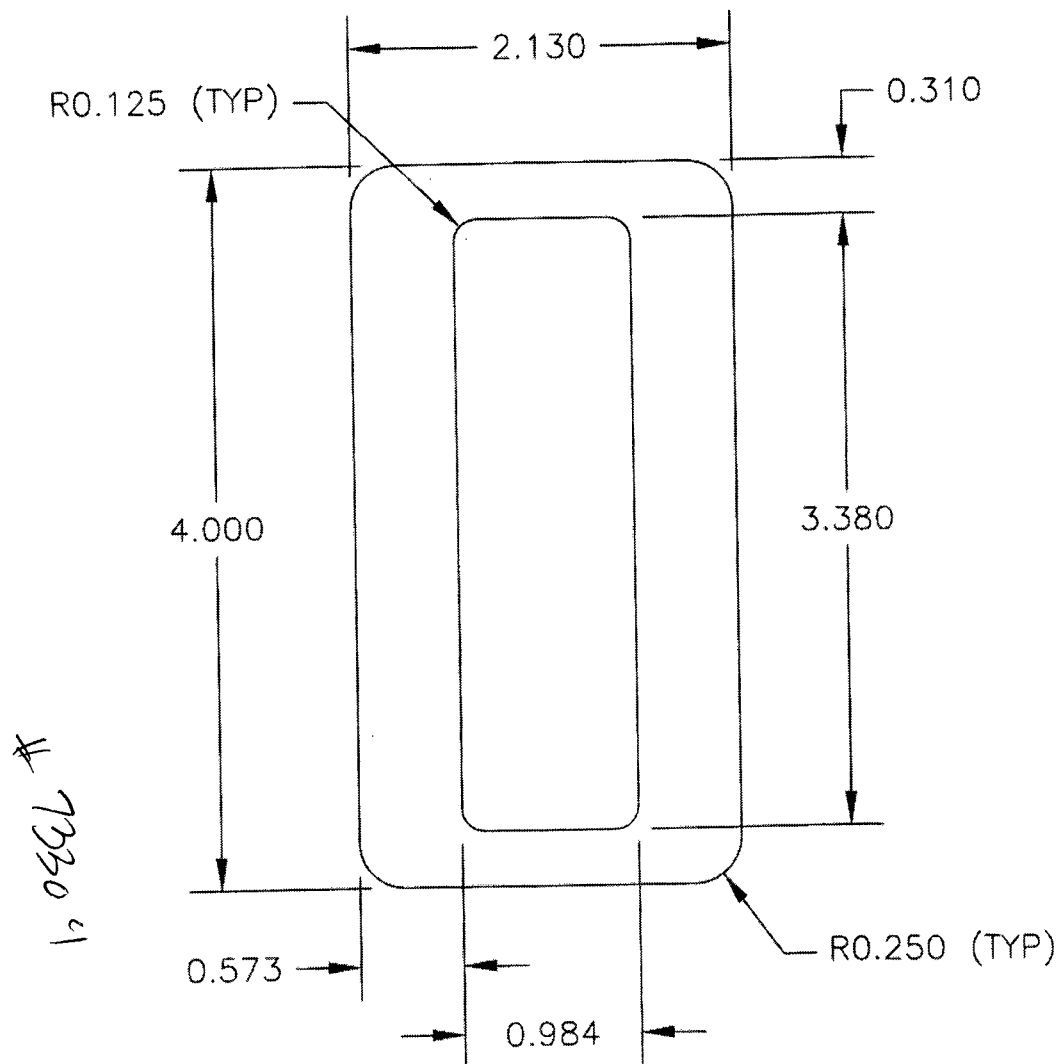
**NOTE:** Date & initial all entries





DESIGN BW	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED  
00.06.05 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3  
(QQ-A-250/4) 0.040 THICK  
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1  
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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